

633-011

Dart Aerospace Ltd.

Date: Friday, 05/09/2008 10:07:48 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: STEP WELDMENT
<b>Job Number</b>	: 41856A		
<b>Estimate Number</b>	: 10176		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2563
<b>This Issue</b>	: 05/09/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2563 REV C
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 41115A	<b>Drawing Revision</b>	: C
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JUL 08.9.05</u>	<b>Due Date</b>	: 30/09/2008
<b>Comment</b>	: Est Rev:G 02.07.31 Re-format Location RF	<b>Qty:</b>	5
		<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2244116	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

1 D2244 Step Extrusion B 33 733 (2)

Batch: B 38023 (3)

SAD 08-12-20

(5)

2.0	D267334	End Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	B 35887

K 08.12.20

5

3.0	D2561	Lug
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

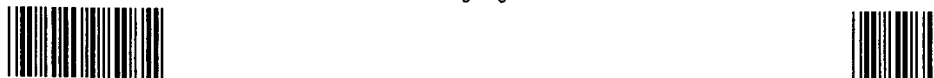
Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	B 40935

K 08.12.20

5

4.0	D2564	Mounting Angle
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	B 40936

K 08.12.22

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 05/09/2008 10:07:48 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41856A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

SAD 08-12-19 (5)

2-Deburr ends

SAD 08-12-19 (5)

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

A/R AL ROD Batch: M109560  
M108037

PH 08.12.22 5

4- Grind

SAD 08-12-22 (5)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BF 08-12-22 (5r)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PH 08.12.22 (5)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CPC PH 08.12.23 5

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PH 08.12.23 5

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M109560  
M108037

3-Grind

PH 08.12.29 5  
PH 08.12.29 5  
PH 08.12.29 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 05/09/2008 10:07:48 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41856A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 08/12/29 (x5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-29 (5)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109996

(SX)

M-L 08/12/29 alodine (SX)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00  
320°F  
1:30

M-L 08/12/30

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

m109219

(5)

FL 09/01/05

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9/1/06

(5x)

59

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/09

(5)

Job Completion



MF 09-01-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

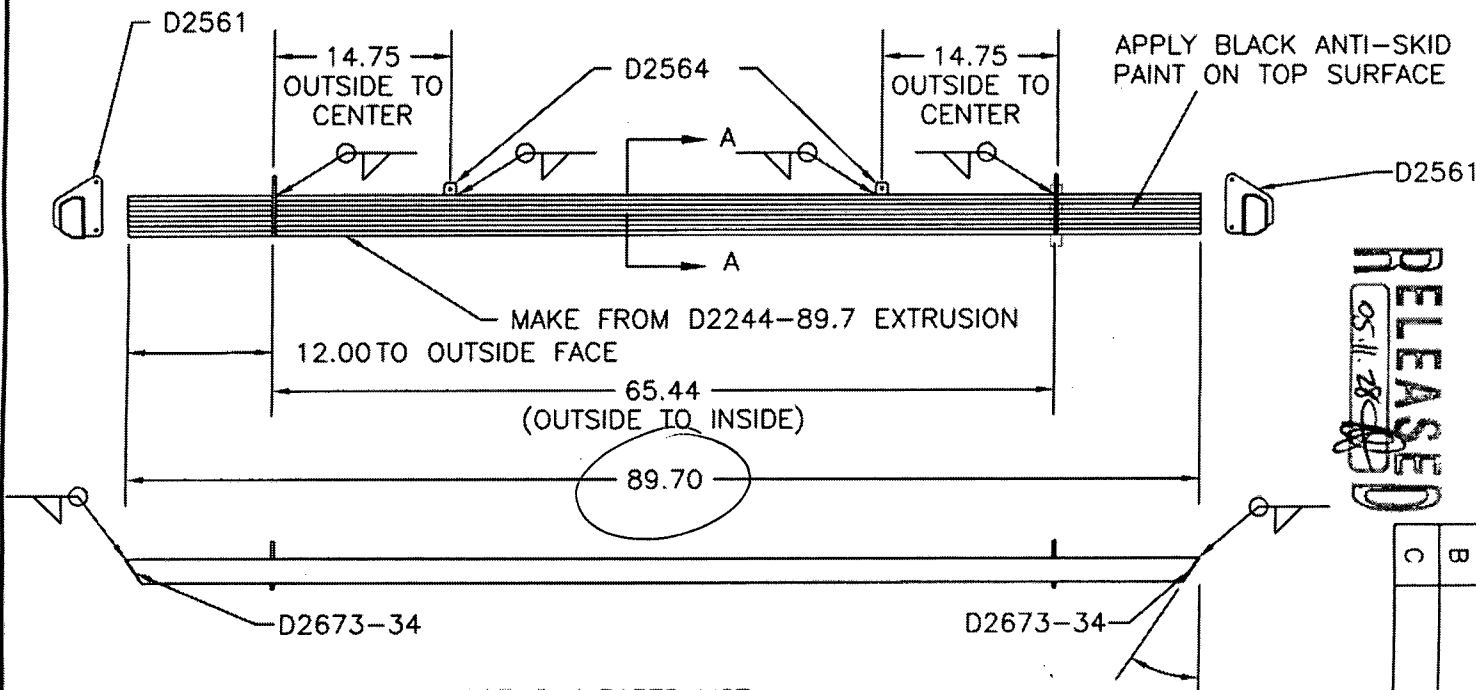
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D2563
DATE	TITLE	SCALE
05.11.14	STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES



#### D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

#### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED